

Date: Thursday, 14/05/2009 11:13:14 AM
 User: Melanie Fauteux

Spent

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM	
Job Number	: 47961-1					
Estimate Number	: 10707					
P.O. Number	:			Part Number	: D2012105	BK
This Issue	: 14/05/2009	S.O. No.	:	Drawing Number	: D2012-105 U/R	09/05/14
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /	Type	: SMALL /MED FAB	Drawing Revision	: D1	
Previous Run	: 47665			Material	:	
Written By	:			Due Date	: 21/05/2009	Qty: 10 Um: Each
Checked & Approved By	: MF 09-05-14					2
Comment	: Est Rev: 02.04.03 Added Inspect level 3 NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 2.7567 f(s)/Unit Total: 5.5134	
		Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)	
		Identify as D2012-101	
		Batch: 17111704	FF 09-05-14
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		1-Punch to length as per Dwg D2012-105 & template D2012-105T1	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Deburr	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING	
		Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	
	START TIME:	7:40	
	OVEN TEMPERATURE:	320°	
			09/05/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2012-105 PAR #: N/A Fault Category: Prod/Fab Assy mal small NCR: Yes No DQA: D Date: 09/05/20
 Resolution: SCRAP Disposition: Scrap QA: N/C Closed: D Date: 09/05/20

NCR:47961		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/14	# 3.0	two struts Bent with wrong angle RL hummer error	09/04/14	Scrap And Destroy And Reissue Qty <u>2</u> M-111704	M-h 09/05/14	S 09/05/14	S 09/05/14	S 09/05/14

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47961

Part Number: D2012105

Job Number:



Seq. #:	Machine Or Operation:	Description :
	FINISH TIME: 8:10	CMD 09/05/15
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		BT 09-05-15 (2)
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
7.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Identify and Stock	
	Location: ST 229	
8.0	QC21	FINAL INSPECTION/W/O RELEASE
		18 09/05/15 (2) 09/05/19 JJ
	Comment: FINAL INSPECTION/W/O RELEASE	

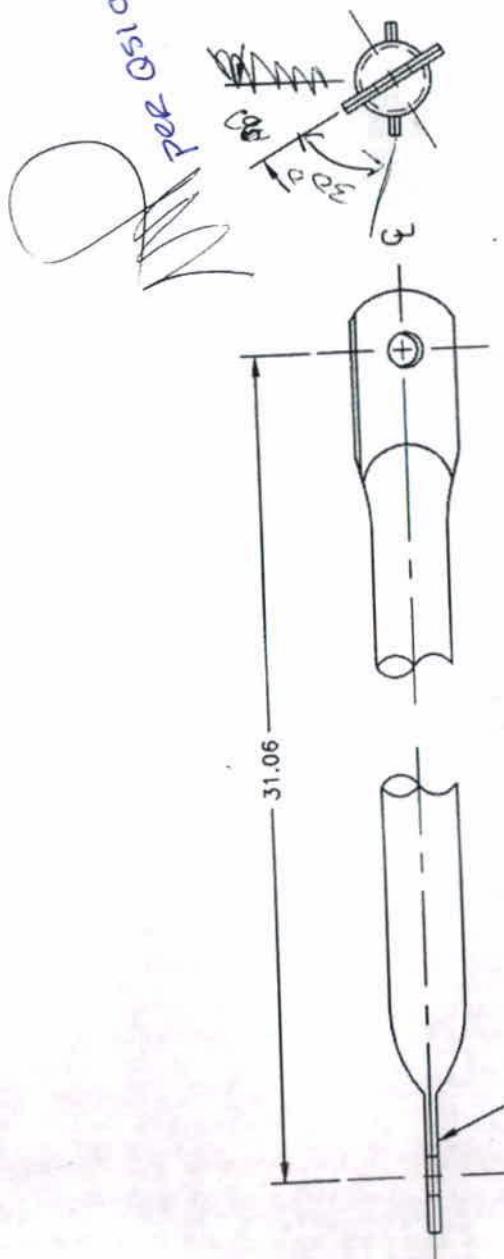
Job Completion


WLF
09-05-15

DART

DESIGN <i>Q</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MR</i>	APPROVED <i>KE</i>	DRAWING NO. D2012-105	REV. D SHEET 1 OF 1
DATE 98.04.28		TITLE ARM	SCALE NTS
A	92.06.04	NEW ISSUE - DRAWN FROM D2012	
B	96.06.25	30° ANGLE ROTATED 60° CCW	
C	97.09.03	CORRECTED VIEWS PER TSR A374	
D	98.04.28	ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
D1	02.03.25	ADD FINISH	

RELEASED
98/05/09 KE



47961

NOTES:
 1. MAKE PER TEMPLATE DT8116 (WAS D2012-105)
 2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.500 \times 0.035$ WALL
 3. FINISH: PANDER CUTT BLACK SANDTEX (4.3 5.7) PER DART Q51005 4.3 12A